

Work Order ID 73599

Tuesday, September 06, 2011 1:52:10 PM

POSITIVE RECALL

EFFECTIVE 11/09/07

RELEASED

AUTH W

DATE 11.12.11 Accept



Page 1

Item ID: D205-634-041

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00

Required Date: 11/14/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-DI

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy D205-634 bluefile & type labels per PPP D205-634-041

swaged tube

0.00

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

SCRAP

CHG 005
CHG 006
ATO

11-9-13

W/O: 73599

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.12.22		N/A Tube was dropped 3 times from 3" height with 7700 ^{lb} total weight on assembled gear to test swaging. Tube was inspected and had no damage. Applied load was typical of average landing. Tube is acceptable	GP	11.12.22	1	GP 11.12.22 051042	
11.12.22	100	Tube is CHG OUS				GP 11.12.22 051642	

Part No: D205-634-041 PAR #: _____ Fault Category: Slide tube NCR: Yes No DQA: Not Date: 12/01/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: X Date: 12/01/23

NCR: <u>111092</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>12416.62</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.12.22		DENT AT ONE WEARPLATE HOLE FROM ENG TESTING	GP 051642	SCRAP Give to eng. GP 11.12.22			GP 051642	GP 11.12.22

NOTE: Date & initial all entries

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for ~~welding as per QSI 004~~

Swaging.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DR
11/09/14
**1 BE 11/09/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 904
A/R Aluminum Rod

1118736

BE 11/09/14

2-Grind welds on step as per Dwg D2580

~~3-Weld spacers as per dwg D2580~~

3- ~~*** N/A ***~~ Insert D4202-1 spacer. swage as per QSI002 and trim/ grind
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

★ SEE WID CHG
- OVER -

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

BE 11/09/15

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091. open to .640" and Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.09.06	140	SWAGE PER DEC- DZ580-D-1 (ATTACHED) USE 6061-T4 60.5mm O.D. x 0.045 WALL. B/N _____				CP 11.09.06 (05) 012	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

*Sub 219
no cracks in + belt spacer
Sound*

see Eng before painting!

POSITIVE RECALL
EFFECTIVE 11-09-06 AUTH [Signature]
RELEASED 11 DATE 11.11.11

1 BR 11-9-22

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Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 11/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

10:45
320
11:15
0.00
OF

1X ✓ m-f 11/04/22

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BK 11-9-22



Work Order ID 73599

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R : Sikaflex-291
Sikaflex expire date: 12-5-11 118393

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R : Sikaflex-291
Sikaflex expire date: 12-6-11 118393

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 118313

1 BL 11-9-22

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Pto →

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

6 11.2.11

Dart Aerospace Ltd

W/O: <u>B73599</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: Re work Disposition: Re work QA: N/C Closed: _____ Date: _____

NCR: <u>testing only no NCR.</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/26</u>	<u>210</u>	<u>Due to swag in tube was Drop tested 3 times Q 3" high. For testing to see if +bolt spacers are were</u>		<u>-> check tube for any cracks in the +bolt spacer on Friday After test.</u>	<u>S 11/09/23</u>			<u>S</u> <u>11/01/26</u>
				<u>Re check two days later</u>	<u>S 11/01/26</u>			
		<u>Go in to crack this time only L.C. no L.C. was for testing only.</u>		<u>- Remove all wear plate + Re powder coat if necessary Grey sandtex Start _____ Fin _____ temp _____</u>	<u>N/A</u>			<u>S</u> <u>11/01/26</u>
		<u>Scrap dated</u>		<u>- touch up Re powder coat tube as required. - Re assemble tube as per Day.</u>				<u>S</u> <u>11/01/26</u>

NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 73599

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1

Manufactured No

140

Each

443.0000

20

20



Spacer

Location

Loc Qty

Loc Code

LG002

443

66929

106

67129

196

67308

1

67430

140

D2580-1

Manufactured No

110

Each

7.0000

1

1



205 Skidtube bent detail

Location

Loc Qty

Loc Code

LG

7

72637

2

72840

1

72965

2

72966

2

D2576-3

Manufactured No

140

Each

24.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

24

66156

24

BE 11/09/15
B72639 x20

DP 11-9-13

BE 11/09/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 73599

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 21.0000 1 1



Cap



Location Loc Qty Loc Code

FP007

21

65519

2

65569 ✓

19

AN3-5A Purchased No

200

Each

909.0000

2

2



Bolt

Location Loc Qty Loc Code

ST350

909

115371

46

117423 ✓

563

118626

300

AN960JD10L NAS1149D0332J ✓ Purchased No

200

Each

0.0000

2

2



Washer

ALS7-1032-130 Purchased No

200

Each

1,155.000

50

50



Insert

Location Loc Qty Loc Code

ST282

1155

117717 ✓

899

118386

256

*ALS4-1032-130.

BL 11-9-22

BL 11-9-22

BL 11-9-22

BL 11-9-22

50.

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Work Order ID: 73599

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 2.103.000 50 50
BOLT



BL 11-9-22

Location Loc Qty Loc Code

ST350	2103	
117313	2	
117688	36	
117795	1	
117872	22	
118012	20	
118112	40	
118451	1000	
118628 ✓	482	50
118706	500	

AN960C10L NAS1149C0332 ✓ Purchased No 200 Each 0.0000 50 50



washer

D3566-13 Manufactured No 200 Each 16.0000 1 1



Gasket

118354



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 73599

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-5 Manufactured No 200 Each 11.0000 1 1
Gasket

Location Loc Qty Loc Code

FP015 11
68961 1
72849 ✓ 10

D3566-1 Manufactured No 200 Each 9.0000 2 2
Gasket

Location Loc Qty Loc Code

FP015 9
68924 2
72848 ✓ 7

D3564-11 Manufactured No 200 Each 17.0000 1 1
Wearshoe

Location Loc Qty Loc Code

FP019 12
73146 12
FP020 5
72207 ✓ 5

D3564-13 Manufactured No 200 Each 12.0000 1 1
Wearshoe

Location Loc Qty Loc Code

FP001 11
72850 ✓ 11
FP017 1
71594 1

BR 11-9-22

BR 11-9-22

BR 11-9-22

BR 11-9-22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73599

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200

Each

7.0000

1 1



Wearshoe



BK 11-9-22

Location

Loc Qty

Loc Code

FP019

5

67590

4

69943

1

FP020

2

72208 ✓

2

D3564-5

Manufactured No

200

Each

23.0000

1 1



Wearshoe



BK 11-9-22

Location

Loc Qty

Loc Code

FG

2

34806

2

FP19

21

73330 ✓

21

D2594-3

Manufactured No

200

Each

436.0000

16 16



O-Ring, 205 Skidtube



BK 11-9-22

Location

Loc Qty

Loc Code

FP-A

436

65518

41

66952 ✓

395

16

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W/O:		WORK ORDER CHANGES					
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Start Date: 9/6/2011

Required Date: 11/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured

No

200

Each

130.0000

16

16



Plug, 205 Skidtube

BL 11-9-22

Location

Loc Qty

Loc Code

FP-A

130

42807

28

67441

7

72127 ✓

95

16.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

LIST OF MATERIALS					DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

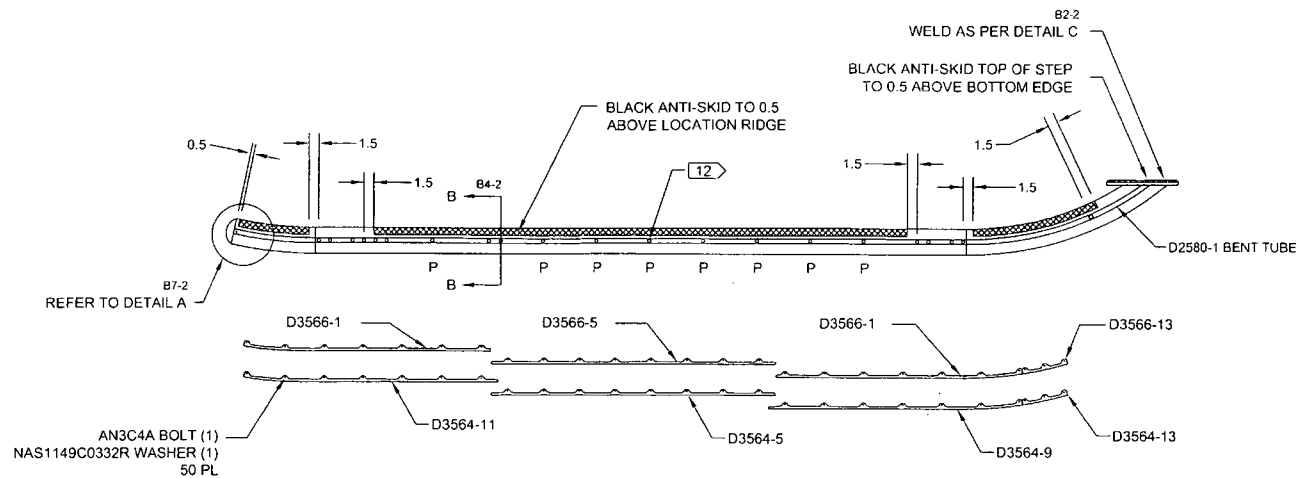
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2011-06-29
W

w/o 73509

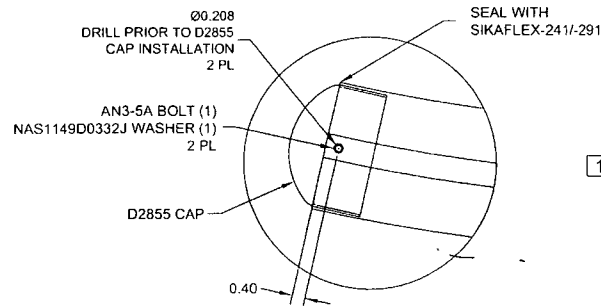
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	RF		
CHECKED	MP		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	11.06.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2580	REV. E SHEET 1 OF 8
TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

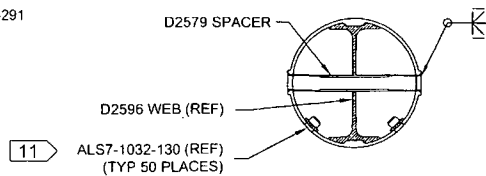


D2580-041 ASSEMBLY DETAIL

DETAIL A
SCALE 5X

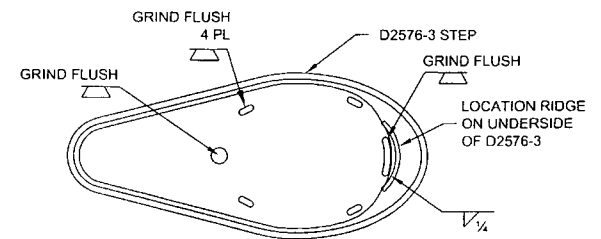


SECTION B-B
SCALE 5X

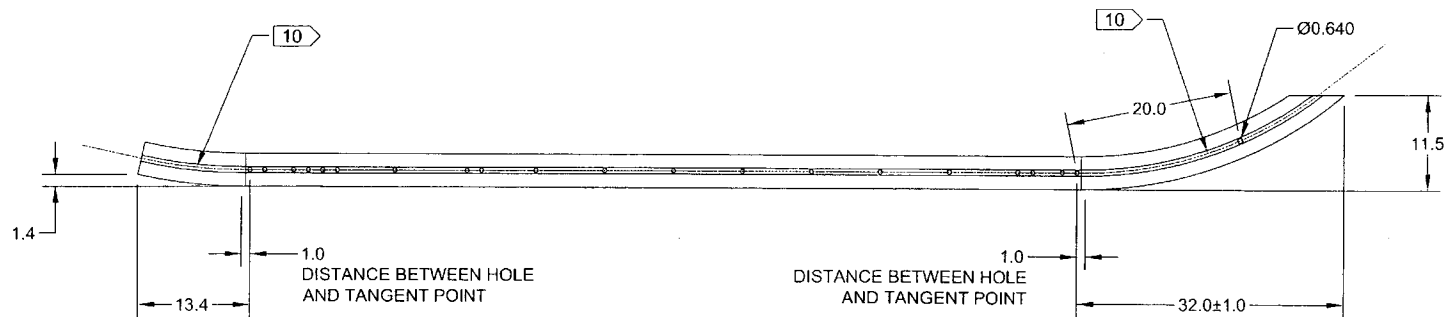


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL C
SCALE 5X



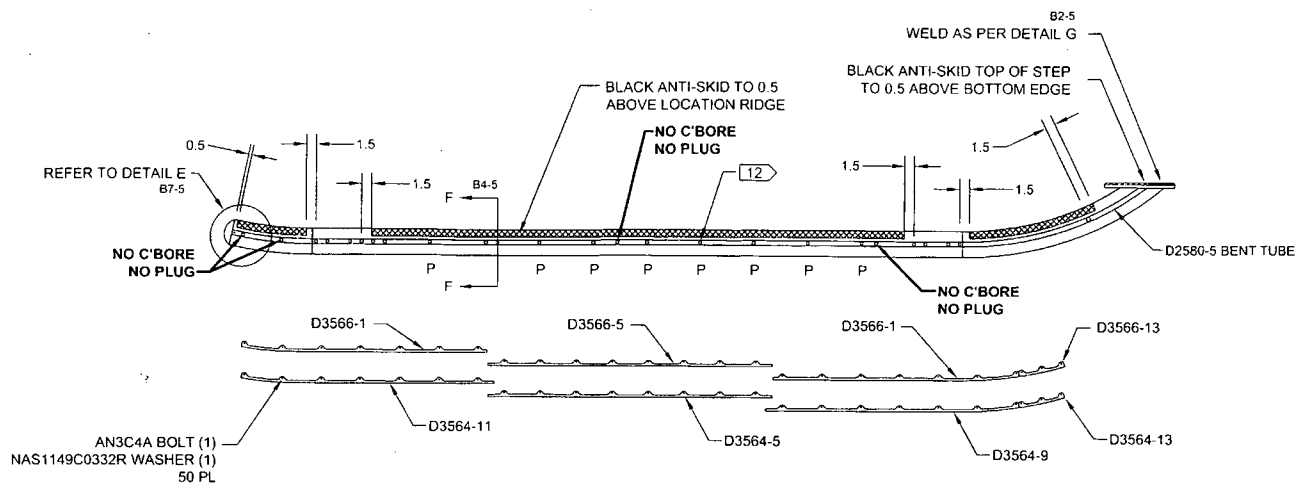
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 2 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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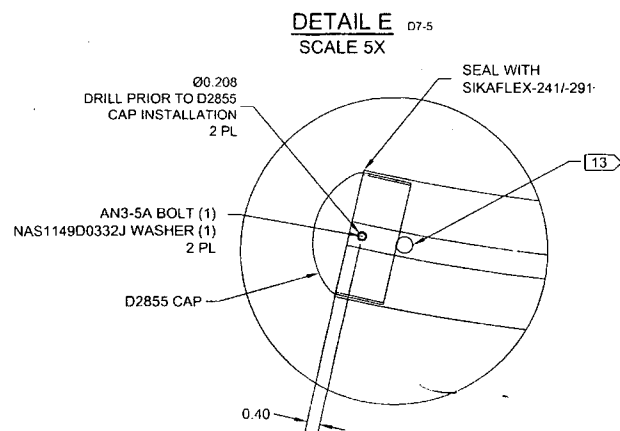
D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2011-08-28

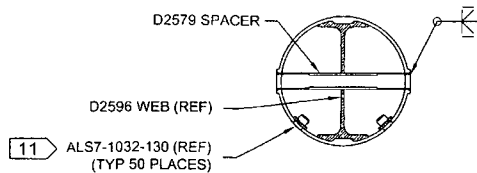
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 3 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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D2580-045 ASSEMBLY DETAIL

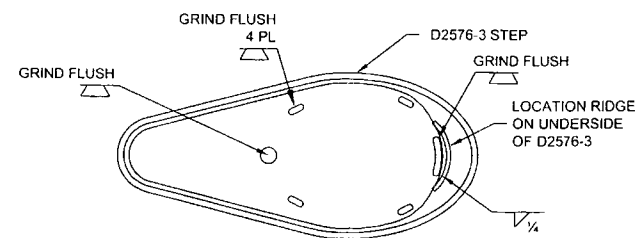


SECTION F-F SCALE 5X



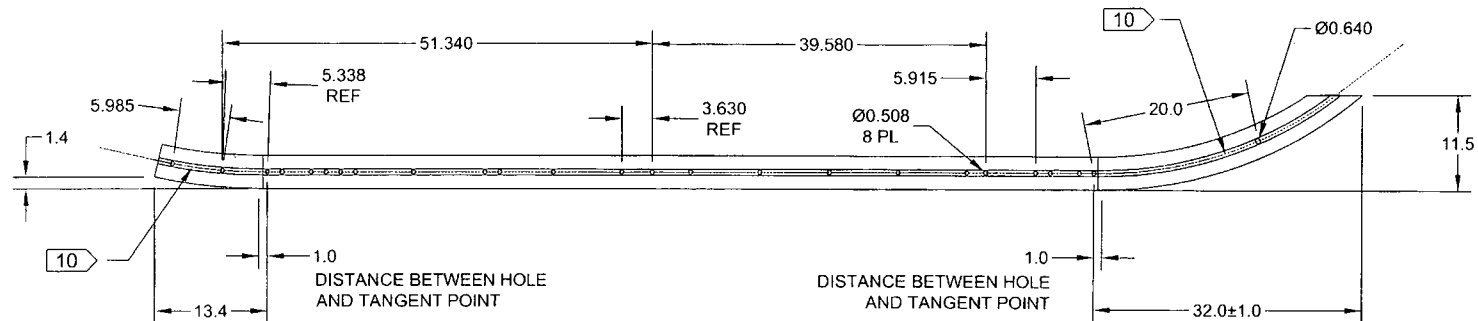
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (24 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL G SCALE 5X



DESIGN	#	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	AP	D2580	SHEET 4 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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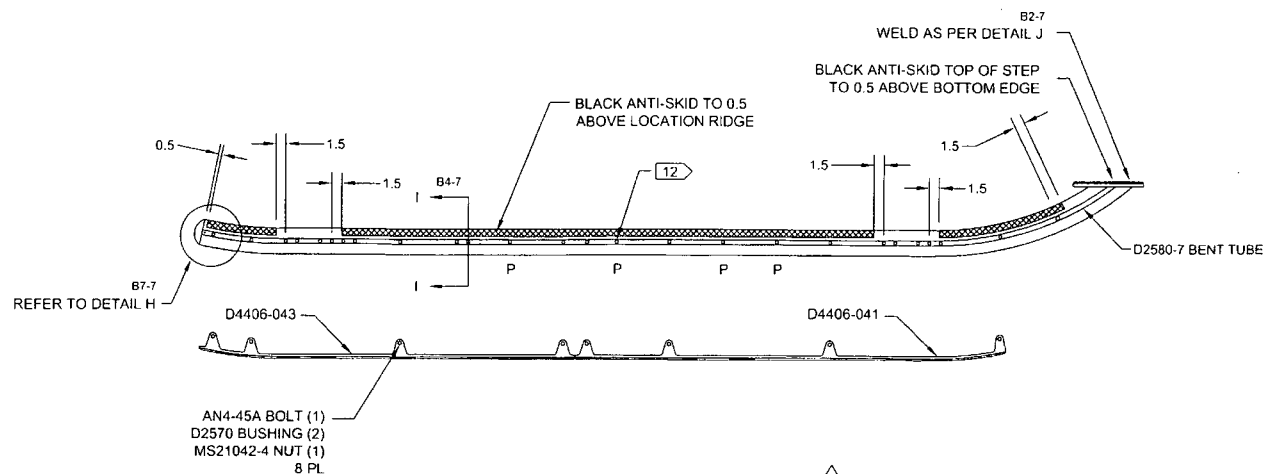
RELEASED
2011-08-29



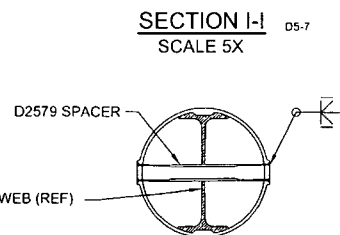
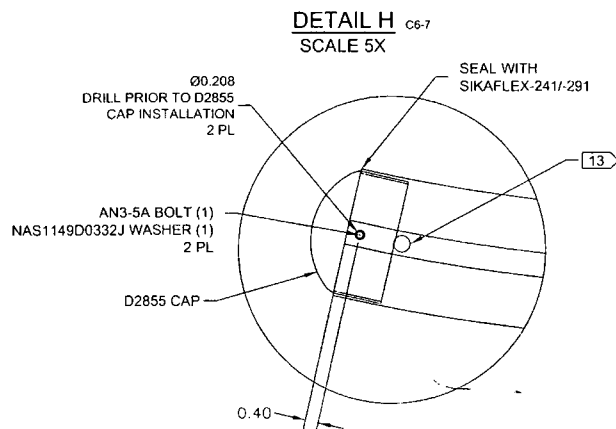
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2011-08-29

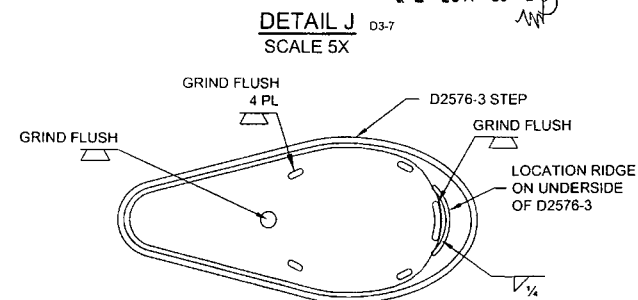
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2580-047 ASSEMBLY DETAIL E

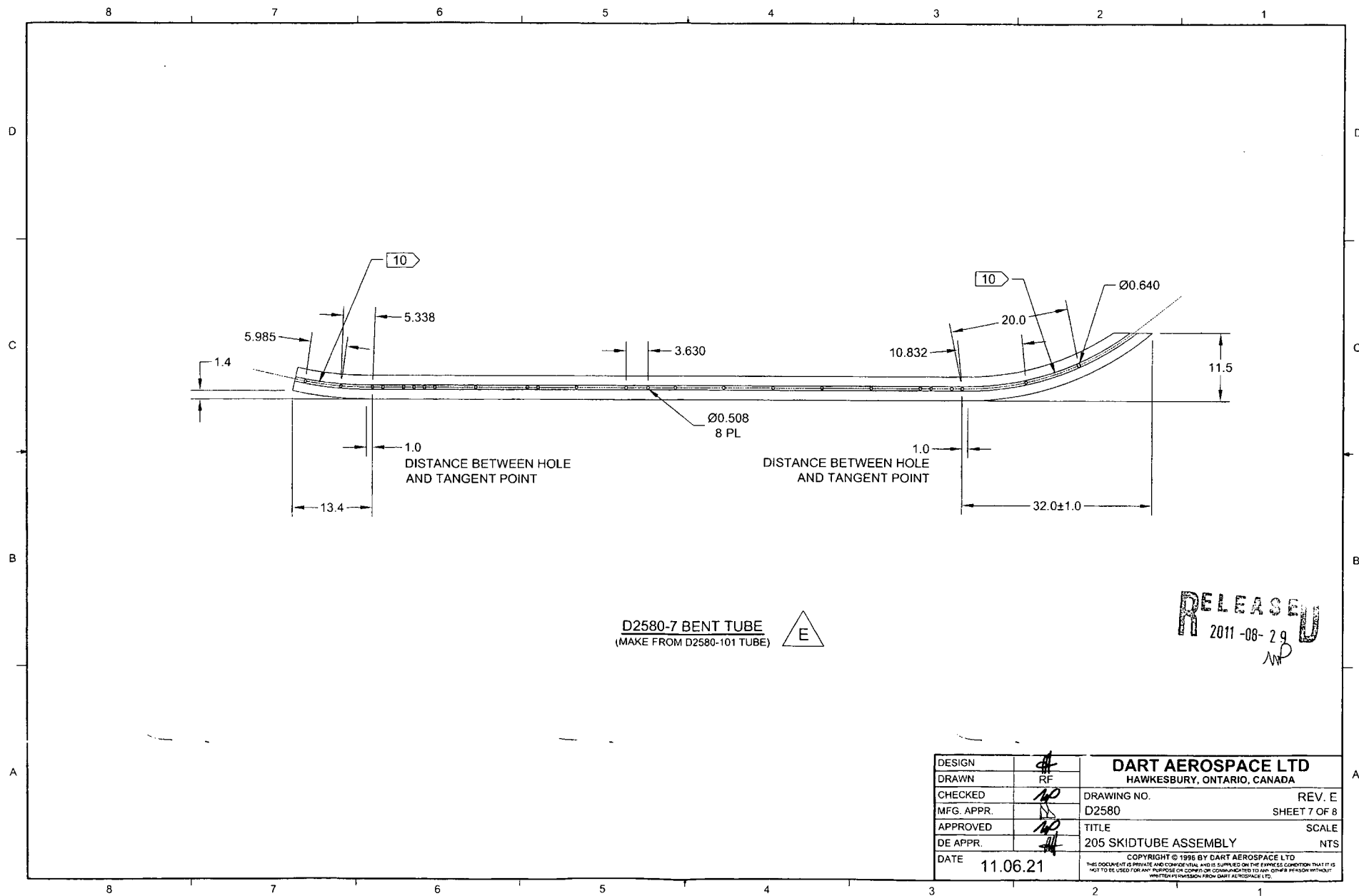


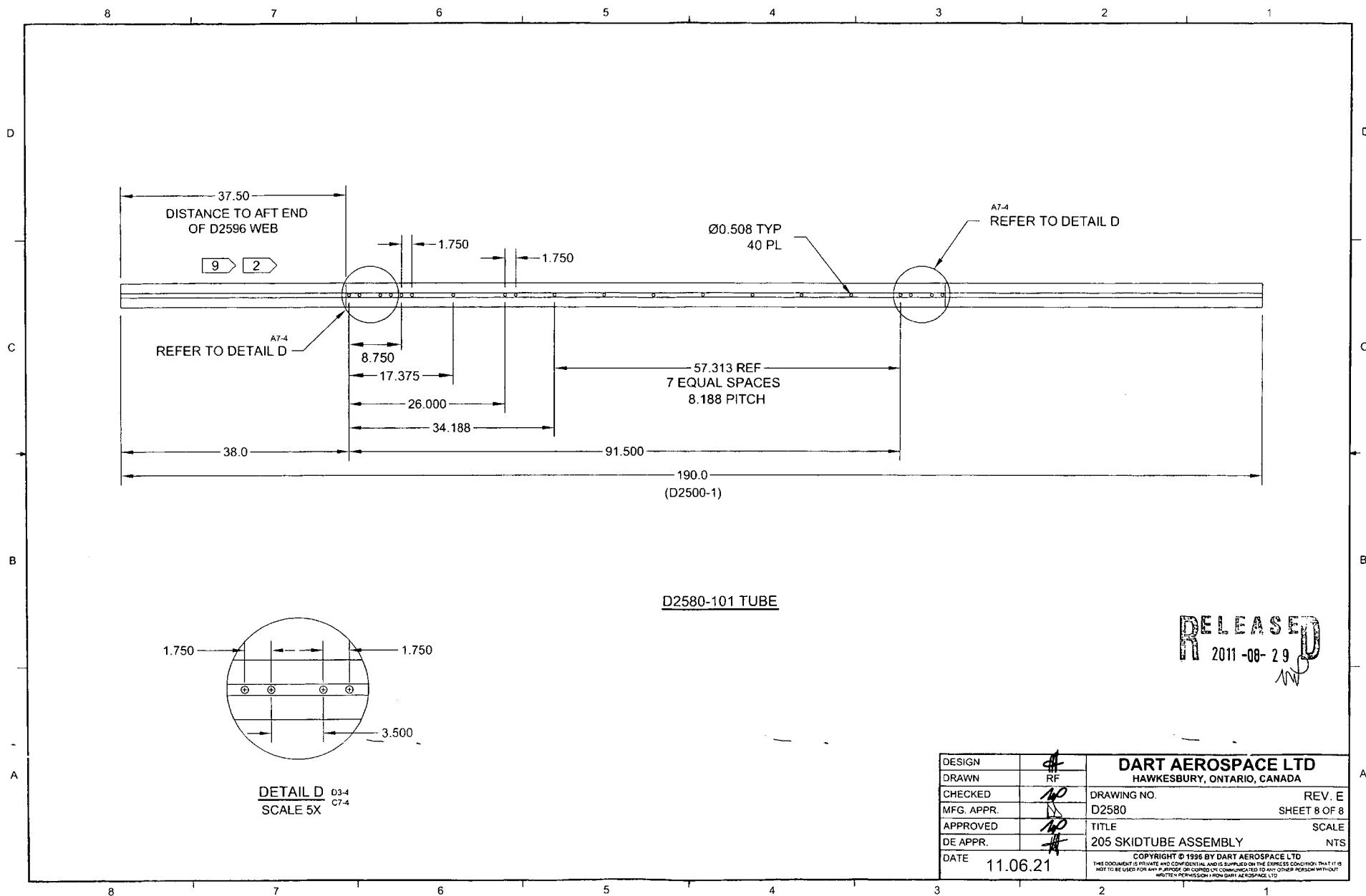
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.300 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (25 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP



DESIGN	#	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-08-29





DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	140	D2580	SHEET 8 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	#	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 11/08/18

Batch No: 118636

Supplier: Metcon

Dart P/O: 14621

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☐ N/A ☐
 Work Order B 72639 N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CG

Production/Admin: 11/08/19
 Date
 Received/Costing CG
 Initial

Location

METCOR INC.

RECEIVED AUG 19 2011

FACTURE / INVOICE

FACTURE / Invoice No.: **8 - 277057**
Date: 17 August, 2011
TERMES / terms: Net 30
Page #: 1 of 1

FACTURÉ À / bill to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY ON K6A 1K7

PAYER À / remit to
METCOR INC.
560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8

LIVRÉ À / shipped to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY ON K6A 1K7

Description	Quantité Part Qty	Poids Part Lbs	Unité Units	Méthode Price Method	Prix Unitaire Unit Price	Montant Amount
-------------	----------------------	-------------------	----------------	-------------------------	-----------------------------	-------------------

FEUILLE TRAVAIL / Order #: **168440** **COMMANDE** / PO #: **14621**

D4202-1

49 1.64

MISE EN SOLUTION / sol aneal

minimum

Min Charge
\$586.00 ✓

Test conductibilite

49 pcs

/ un

\$1.80

\$88.20 ✓

TVH / hst

\$ 87.65

TPS / gst # R-103649661
TVQ / qst # 1001474100

TOTAL: \$ 761.85

Téléphone: 450-473-1884

Fax: 450-491-5498

Purchase Order Receipt Listing

Page 1 of 1

Friday, August 19, 2011 11:46:37 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO14621 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert/Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
Vendor ID\Vendor Name		VC-MET004	Meteor Inc.								
PO14621	1		72639		8/10/2011	8/19/2011	49.0000	\$13.96	0.0000	0	\$684.04
CAD	No		D4202-1 Heat treat to condition T4 118636		49.0000	LAV001		\$684.04	0.0000	0	
									Total Received Quantity:		49.0000
									Total Qty to Inspect (PO U/M):		0.0000
									Total Reject Quantity:		0.0000
									Total Receipt Value:		\$684.04
									Total Balance Due Quantity:		0.0000

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Recu de Livraison

Order	Shipper	Shipping Seq.
168440	1	53188

Shipped Complete

Customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Shipped To:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
14621		AL-6061	2011/8/4	FEDEX
Quantity	Part No. / Part Name / Part Description			Pounds
49	D4202-1 1 BOITE DE CARTON ✓			1,64

CL110818

Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

PACKING	
----------------	--

Quantity Shipped: 49
Pounds Shipped: 1,64
Quantity Remaining: 0
Pounds Remaining: 0,00

Quantity Shipped: 49

Pounds Shipped: 1,64

Signature:

Date:

Shipped ON: 2011/08/12

701-2

DVJE 5014-08-JS

CONFIDENTIAL - CONTINUED

13	121	1 BOITE DE CHAMON DE 500-1
CHAMON CHAMON	BOITE BOITE	CHAMON CHAMON

NY 100-10554

FOR RELEASE NOVEMBER 11, 2001

NOBDATE	00 F0000000	40	00 - 00 4437
---------	-------------	----	--------------

CONFIDENTIAL, 32-73 AGC 2, 6 38-33, 1-1

REF ID: A66768

STATE WORKING CONDITIONS
SOP - 1000

ĐIỂM ĐÓNG

SPECIFIC WORK ON PROCEEDS

[illegible]

U.S. DEPT. OF JUSTICE
FEDERAL BUREAU OF INVESTIGATION
COMMUNICATIONS SECTION
OFFICE OF THE DIRECTOR

14-00000
 14-00000
 14-00000
 14-00000

508470

626

2. M. DE LEVANT (HUSCENI)

GLYCOSYLATION OF MONOMERICS

SECRET

6007 2000

23. 24.



Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél.: (450) 473-1884
Fax Administration: (450) 491-5498
Fax Production: (450) 491-6454

Certificat de Conformité
Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
168440	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
14821		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

□

CL1103118

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

CONDUCTIVITY 35 - 43 %IACS 10 38 - 39 %IACS

HARDNESS 60 HREW MIN 10 65 - 68 HREW

DURETÉE MESURÉE EN HR15TW = 65.3-67
HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
49	1.64	D4202-1 1 BOITE DE CARTON

COMMENTAIRES / comments

INSPECTEUR / inspector:

DATE: 2011-08-12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14621

Purchase Order Date 8/3/2011

PO Print Date 8/3/2011

Page Number 1 of 1

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Contact Name

Vendor Phone 450 473 1884

Vendor Fax 450 491 5498

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Currency

FOB

Brigitte Golden

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	72639	D4202-1 Heat treat to condition T4	8/10/2011 Yes	40.00 49	FedEx Overnight	150.0000	\$0.00

PO Total:

\$0.00

Ref: P014621
Dep:

Date: 03Aug11
Wgt: 2.0 LBS

DV:

0.00

SHIPPING: 19.14
SPECIAL: 3.97
HANDLING: 0.00
TOTAL: 23.11

Svcs: PRIORITY OVERNIGHT
TRCK: 9018 2261 3883

Please advise on \$
&
lead time

TKS

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 8/3/2011

[illegible]

Brigitte Golden

From: Alain Lemieux <alainl@metcor.biz>
Sent: Friday, August 05, 2011 11:08 AM
To: bgolden@dartaero.com
Subject: RE: PO14621 from Dart

Hi Brigitte

The price for the treatment is \$586.00 plus \$88.20 for the conductivity test as per quotation 3135.
Is there a spec and in which condition the piece are?

Alain Lemieux

Metcor Inc.

Tel. : 450-473-1884

Fax. : 450-491-6454

Alainl@metcor.biz

De : Marie Jacob
Envoyé : 5 août 2011 09:44
À : Alain Lemieux
Cc : Brigitte Golden
Objet : FW: PO14621 from Dart

From: Brigitte Golden [mailto:bgolden@dartaero.com]
Sent: August 5, 2011 8:07 AM
To: Marie Jacob
Subject: RE: PO14621 from Dart

Désolé!
Voici le PO14621
S.V.P. nous avons besoin du prix!!

Merci!!

From: Marie Jacob [mailto:mjacob@metcor.biz]
Sent: Thursday, August 04, 2011 5:31 PM
To: Brigitte Golden
Subject: RE: PO14621 from Dart

Désolé mais j'ai besoin d'une correction pour le p.o. 14621 et non 14629.
Nous avons reçues 49 pcs sur le p.o. 14621 qui en indique 40.
Merci de votre collaboration et bonne soirée!
Isabelle.

Isabelle Mainville
En remplacement temporaire de:

Marie Jacob

ING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED L	MFG. APPR. B	APPROVED MP		DE APPR. H		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

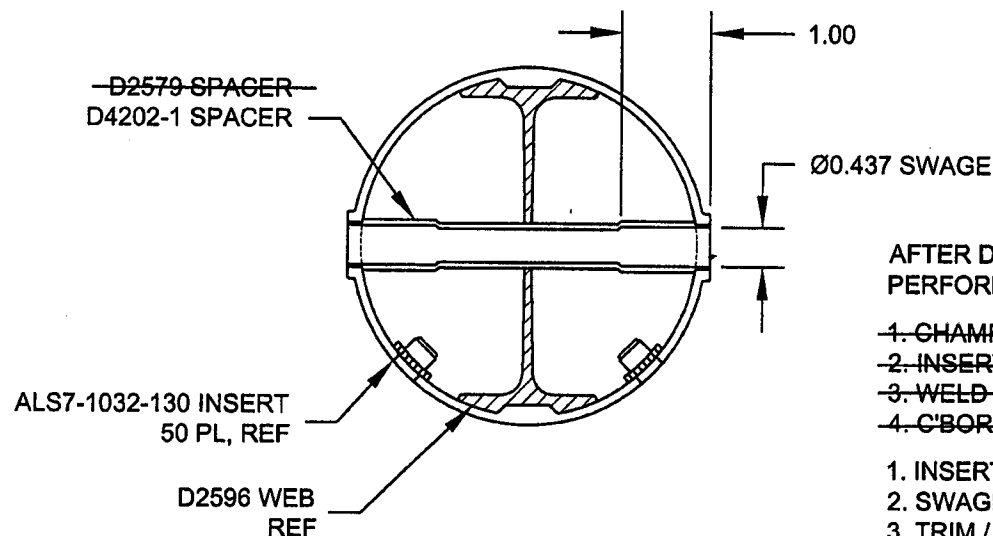
QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

→ USE 6061-T4 TUBING *SEE W/D CHG

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)-
3. WELD INTO PLACE AND GRIND FLUSH-
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP-

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

UNDER REVIEW

UP 11.06.30

SUPERCEDED BY

Rev D UP 11.06.30

OK UP 11.05.06

RELEASED
2010-11-18

Eric Downing

From: Bill Beckett <bbeckett@dartaero.com>
Sent: September 19, 2011 1:38 PM
To: 'Eric Downing'
Cc: 'Chris Provencal'; 'David Shepherd'; 'Susanne Sheldon'; 'Linda Lacelle'; 'Stow, Dan'; 'Mike Petsche'
Subject: RE: Swage 205 skid

Eric,

If the tube is not damaged during this testing, we intend to keep it for shipment to a customer. Therefore, we need to assemble wearplates, first, to have a representative drop test, and then to protect the tube. Because it is much cheaper, we will paint first, and then assemble. We just need to be careful during testing not to scratch the tube. As long as the crossbolt spacers are free of paint, we will be able to inspect for cracks.

Bill

From: Eric Downing [mailto:edowning@dartaero.com]
Sent: September 19, 2011 12:41 PM
To: 'Mike Petsche'
Cc: 'Chris Provencal'; 'David Shepherd'; 'Bill Beckett'; 'Susanne Sheldon'; 'Linda Lacelle'; 'Stow, Dan'
Subject: RE: Swage 205 skid

Quick question

Do we install all inserts and wear plates?

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: September 19, 2011 10:53 AM
To: Eric Downing
Cc: Chris Provencal; David Shepherd; Bill Beckett; Susanne Sheldon; Linda Lacelle; Stow, Dan
Subject: Re: Swage 205 skid

Ok per the latest conversation.

Russ will get the drop test rig ready this week. Dan is still away. Russ is also helping sian and jl. So he thinks he can have it all ready later in the week

We are going to run it through the powder coat oven too (though it won't get actually powder coated). But this will give it a bit of a thermal work out too. (they are calibration the oven right now so this can be their test part).

Now all that said I'm not sure what we will do if something fails during this process. But I guess we can jump off that bridge when we get to it.

Sent from my iPhone.

On 2011-09-19, at 8:28 AM, "Eric Downing" <edowning@dartaero.com> wrote:

Good morning guys

I just finished the D205 skid that was done with the new x-bolt spacers. I didn't find or see any cracks in them and the saddles fit great. What do we do now the work order has a note to see Engineering before powder coat. Do you guys want to see it? And what do we do with it after powder coating and assembly?

Let me know please in till you tell me I'll keep the tube on the Quarantine rack with the work order.

Thanks

Eric Downing

QC COORDINATOR

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